

Work Order ID 69407-2

Tuesday, May 10, 2011 3:25:25 PM

SPLIT



Page 1

Item ID: D2435

Revision ID:

Item Name: Bearpaw, 206

Start Date: 5/10/2011 Start Qty: 8.00

Required Date: 5/16/2011 Req'd Qty: 8.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 11-08-15

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2435

Rev E1

120



0.00

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

CUT BLANK AS PER FILE D2435

B11-5-1



130



0.00

HAAS I

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA789 and Dwg D2435 Identify as D2435
3-Deburr

Y.A 11/08/15

SL 11-08-16

8/12

140



0.00

QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

Y.A 11/08/15

SL 11-08-16

8/12

D350-689-017 X 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69407

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Page 2

Item ID: D2435

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw, 206

Start Date: 5/10/2011 Start Qty: 8.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

OK 11/08/16
OK 11/08/17

128

151

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11/8/14 S(12)

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/18

11-08-14
(12)

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, May 10, 2011 3:25:45 PM

Page 1

Work Order ID: 69407

Parent Item: D2435

Parent Item Name: Bearpaw, 206




Start Date: 5/10/2011

Required Date: 5/16/2011

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10  UHMW 1" Black		Purchased	No			120	sf	163.0000	3.2	25.6			



BL-5-11

Location

MAT018

116554

117321

Loc Qty

163

2

161

Loc Code

117321



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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	69407
Description: Bearpaw		Part Number:	D2435
Inspection Dwg: D2435 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A 0.063 x 45°	+0.030/-0.010	0.054 x 45°	✓		Vern	GA-01
B 5.500	+/-0.030	5.501	✓		"	"
C 0.200	+/-0.030	0.202	✓		D-G	GA-08
D R0.250	+/-0.030	R0.250	✓		R-G	ref.
E 0.250	+/-0.010	0.248	✓		Vern	GA-01
F 0.625	+/-0.030	0.625	✓		"	"
G 0.25 x 45°	+/-0.030	0.275 x 45°	✓		"	"
H 0.375	+/-0.010	0.375	✓		"	"
I 19.000	+/-0.030	19.000	✓		TAPE	GA-12
J 0.950	+0.030/-0.010	0.958	✓		Vern	GA-01
K Ø0.260	+0.005/-0.000	Ø0.260	✓		"	"
L Ø0.930	+/-0.030	Ø0.926	✓		"	"
M 0.30	+0.030/-0.000	0.312	✓		D-G	GA-08
N 0.375	+/-0.030	0.377	✓		Vern	GA-01
O 7.375	+/-0.030	7.377	✓		Vern	CNC-02
P 4.250	+/-0.010	4.250	✓		Vern	GA-01
Q 2.000	+/-0.030	1.999	✓		"	"
R 9.000	+/-0.010	9.000	✓		Vern	CNC-02
S 15.750	+/-0.030	15.750	✓		TAPE	GA-12

Measured by:	B.A
Date:	11/08/15

Audited by:	am
Date:	11/08/16

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O K10007	KJ/RF	✱

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DART



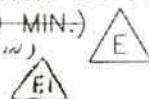
RELEASED
19 OCT 17 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMMERSBURY, ONTARIO, CANADA	REV. E
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2435	SHEET 1 OF 2
DATE 98.05.19	TITLE BEARPAW	SCALE 1:5	

A	96.01.24	NEW ISSUE
B	96.03.26	CHANGE BORE AND C'BORE DEPTH
C	97.05.07	CHANNEL & C'BORE DEPTH CHANGED
D	97.10.17	R1.5 BORE WAS R2.637 (TSR A469)
E	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50

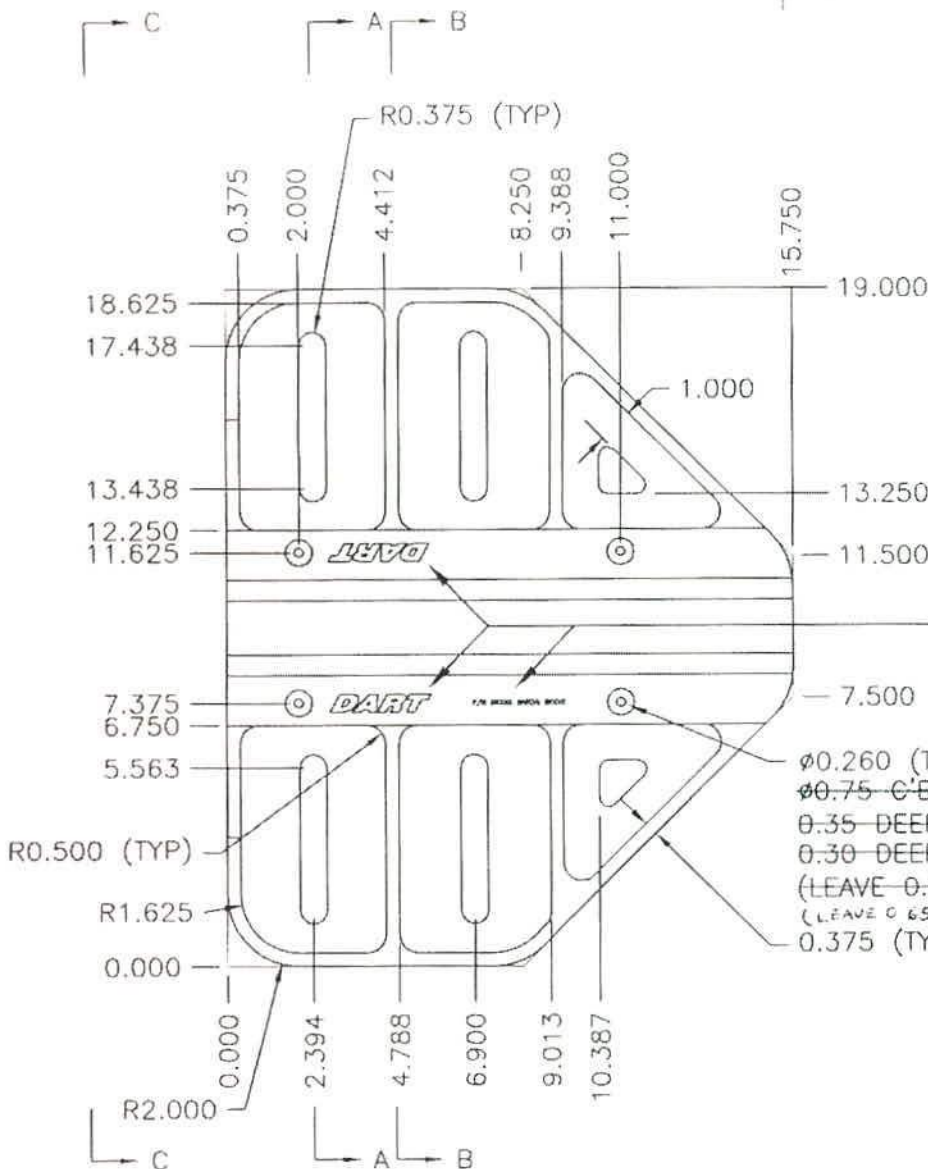
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *69407*
11-05-10



Ø0.260 (TYP) Ø0.93 C'BORE
Ø0.75 C'BORE 0.30 DEEP FROM BOTTOM
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375 (TYP)

9143



MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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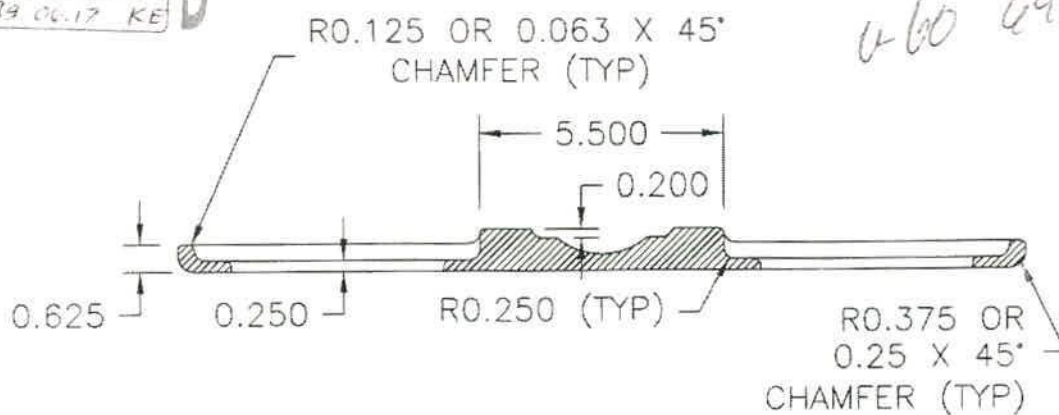
NOTE: Date & initial all entries



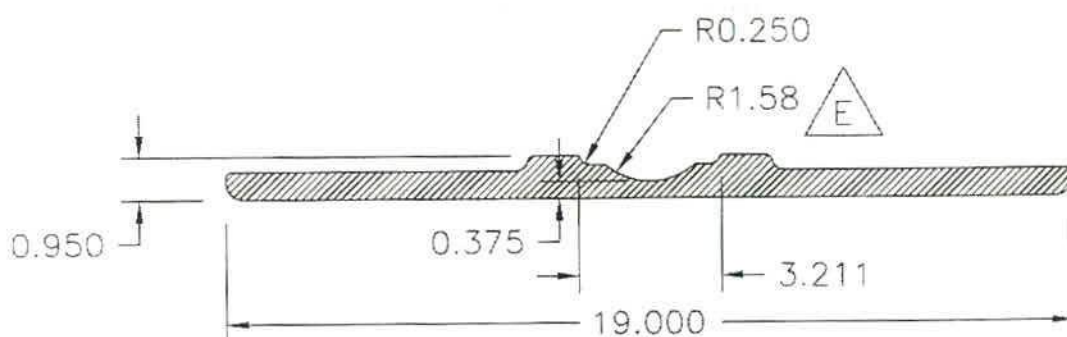
DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED BB	APPROVED [Signature]	DRAWING NO. D2435	REV. E SHEET 2 OF 2
DATE 98.05.19		TITLE BEARPAW	SCALE 1:4

RELEASED
99.06.17 KE

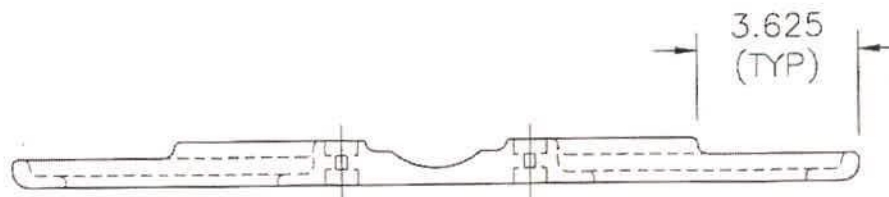
460 69407



SECTION A-A



SECTION B-B



SECTION C-C